Qty:

Friday, 11/18/2005 5:29:30 PM

Linda Lacelle

Process Sheet

Customer

: CU-DAROO1 Dart Helicopters Services

: 24876

Job Number **Estimate Number**

P.O. Number

: 10333

This Issue

Prsht Rev.

First Issue

: NIA

: 11/18/2005

: NC

: 24111

S.O. No. : NIA

: NIA

: SMALL /MED FAB

Part Number **Drawing Number**

Drawing Name

: D2530 . D2530 REV B

Project Number **Drawing Revision**

Material **Due Date** : NIA

: 12/20/2005

: HANDLE WELDMENT

20 Um:

Each

•

Previous Run Written By

Comment

Checked & Approved By

: Est Rev:E

Removed Purchasing

05-11-07

JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

24876A

LOCK PLATE



Comment: Sub-Component LOCK PLATE

2.0

M304TR1000WO49

304 RD Tube 1.0" x .049W



Comment: Qty.:

0.4809 f(s)/Unit Total:

9.6180 f(s)

Material: 304/316 SS Seamless Tubing 0.75" OD x 0.049" wall(M304TR0.750W.049)

Batch: <u>M1x983</u>

SMALL & MEDIUM FAB RESOURCE 1



3.0 SMALL FAB 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2536

2-Deburr

Lock Plate

4.0

D2534

Comment: Qty.:

1.0000 Each(s)/Unit Total:

20.0000 Each(s)

Pick:

QTY

2

Part# D2534

Description

Lock Plate

Batch B.24876A

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301

Page 1

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W/O:			WORK ORDER CHANGES	•				
DATE	STEP	29 (1) 1	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				-				: .
					grad Grade			

Part No:	PAR #:	Fault Category:	- 1	N	ICR: Yes No DQA:	Date: 06/01/25
		 ;	1			
3	•		•		QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)													
		Description of NC		Corrective Action Section B	,	Varification		Approval							
DATE	STEP	Section A	Initial Chief Eng			Verification Section C	Approval Chief Eng	Approval QC Inspector							
CE.1.19	5.0	welded hardle together did. Not sit flush at both ends so it was twisted to sit better end but was twisted to much and was no good	de	made a new part to finish the order	06-1-19	Do ry	Brown	100 cool. 9							
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NOTE: Date & initial all entries

Friday, 11/18/2005 5:29:30 PM Linda Lacelle User: **Process Sheet Drawing Name: HANDLE WELDMENT** Customer: CU-DAR001 Dart Helicopters Services Part Number: D2530 Job Number: 24876 Job Number: Description: Seq. #: **Machine Or Operation:** 2-Deburr WELD INSPECTION QC5/9 6.0 Comment: WELD INSPECTION POWDER COATING 7.0 POWDER COATING Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock CZORION Location: 185 DOCUMENT CONTROL DC 10.0 Comment: DOCUMENT CONTROL 06/01/23 20 Inspection Level 21 Job Completion

Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date: NCR: WORK ORDER NON-CONFORMANCE (NCR) DATE STEP Description of NC Corrective Action Section B Verification Approval Approval Approval	Dart Ae	rospace	e Ltd	•	!	1	1									
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Job Costing Report

Dart Aerospace Ltd. Nov 18, 2005 Hawkesbury 09:21 am

Work Order No : 0024876
Project Name : D2530 Department Code:

Project For : WK549 Burden Flags : NNNNNNN Work Order Type : Main WO Status : Open

Main WO Number : Invoice State : Not Invoiced

House Part Number : D2530 Invoice Date :

Description : Handle Weldment Invoice Number :
Manufactured : Yes Invoice Amount : 0.00

Manufactured: Yes Invoice Amount:
Amount Req'd: 20

Amount Done : 0 Order Entry No : Start Date : 11-18-05 OE Value : 0.00

Est Finish Date : 12-05-05

Act Finish Date : Est Margin : 0.000% Drawings Reqd : No Actual Margin : 0.000%

Ok for Approval :

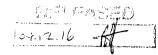
Approval Rec'd : \$0 Posted to Finished Goods

		Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		•
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	·:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
		========	========	======		
Burden	:	0.00	0.00	0.00		
		=======	===========			
Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000			
Selling Cost	:	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00

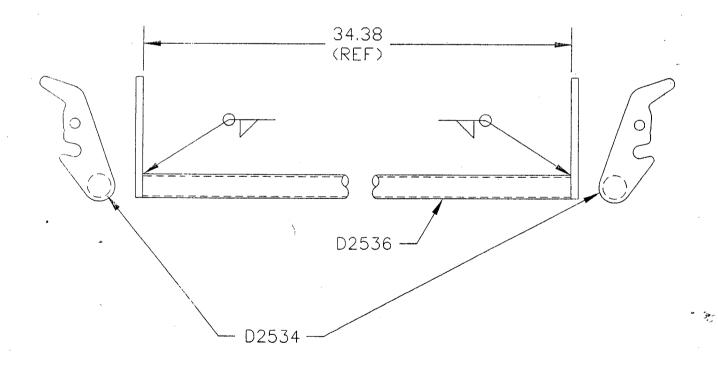


DESIG	N ILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECH	ED M	APPROVED	DRAWING NO.	REV. B
	TIT	· M	D2530 SHEET	1 OF 1
DATE			TITLE	SCALE
04.1	2.14		HANDLE WELDMENT	
Α		96.06.18	NEW ISSUE	
В		04.12.14	UPDATE NOTES AND DIMENSIONS	



PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536 ·	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED